the same radius as the slot *B* in the fixture. A weight is attached to the saddle of the machine by means of a wire cable which is connected at *D.* The object of using a weight is to hold block *C* in contact with the slot on one side, and thus by eliminating all play it is possible to secure a higher degree of accuracy. A two-lipped end-mill is used for this operation. The slot is milled 0.8 inch wide and if inch deep. Another radial fixture of the general type just described is

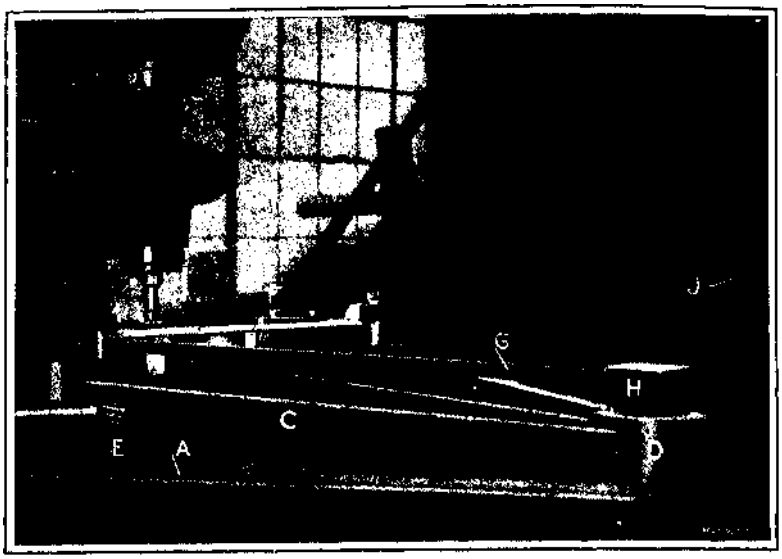

Fig. 18. Radial Milling Fixture used for Different Operations on Sight-bar

shown in Fig. 17. This fixture is for the bronze bracket through which the sight-bar slides when being elevated or lowered. It has a curved slot which must be milled to the same radius as the sight-bar to avoid any cramping or binding action. A finished surface on the bracket *A* is clamped against a top plate

or bridge *B* of the fixture, and it is further located by a plug C at the right. The base of the fixture fits between curved tracks or guiding strips *D.* At one end of the fixture a transverse slot is formed, and this is engaged by a block pivoted to a nut through which the feed-screw passes. The feed-screw is connected by gearing *E* with the regular feed-rod of the machine,